

Work Order ID 79679

May-30-12 3:55:16 PM

79679

Page 1

Item ID: D212-664-107TRN

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Crosstube Turning Detail

Start Date: 31/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 02/02/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/05/31 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D212-664-147

Rev B(DE0)

100

0.00

100

MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA705.

2-Turn first side as per Folio FA113

3-Blend transition lines only, **do not sand whole tube**.

FOLIO REV: AADWG REV: B

*Use mill bastard file, brush file repeatedly with file card.

*Do not use sandpaper coarser than 320 grit.

110

QC1- Inspect dimensions to dimension sheet

0.00

110

QC

Memo

0.00

Quality Control.

mmml
12/06/21

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 79679

May-30-12 3:55:16 PM

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Page 2

Item ID: D212-664-107TRN

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Crosstube Turning Detail

Start Date: 31/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 02/02/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

120

0.00

120

MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Turn second side as per Folio FA705

2-Blend transition lines only, **do not sand whole tube**:

*Use mill bastard file, brush file repeatedly with file card.

*Do not use sandpaper coarser than 320 grit.

FOLIO REV: 11

DWG REV: 13

3- Remove plugs and sand

130

QC1- Inspect dimensions to dimension sheet

0.00

130

QC

Memo

0.00

Quality Control

MAN-L
12/06/22

MAN-L
12/06/22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Turning Detail

Start Date: 31/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 02/02/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC8- Inspect parts - second check

0.00

140

QC

Memo

0.00

Quality Control

DP 12-6-26

145

0.00

145

Crosstubes

Memo

0.00

Crosstubes

GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.

Rm 12-6-28

150

~~Crosstubes Chemical Conversion~~

0.00

150

HandFXtube

Memo

0.00

Hand Finishing Crosstubes

mm 12-7-3

**** Use Wash & Wipe to clean inside and outside of tube with scotch brite. Wear rubber or latex gloves to handle crosstube ****

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

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Page 4

May-30-12 3:55:17 PM

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N900040100

Setup Start

NS1

Revision ID:

Item Name: Crosstube Turning Detail

Stop

NS2

Start Date: 31/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 02/02/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

DP 12-7-3

170

Packaging

0.00

170

Packaging

Memo

0.00

Packaging

Identify and stock in kanban rack
Location: 4/6

DP 12-7-3

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/7/4

ME
12-07-03

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

| | | |
|--|--|----------------------------------|
| DART AEROSPACE LTD | | Work Order: 79679 |
| Description: Crosstube Assembly (205/212/412 Low Fwd) | | Part Number: D212-664-147 |
| Inspection Dwg: D212-664-147 Rev: B | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Inspection Sheet Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---------------------------------------|-----------|---------------------|---------|--------|-------------------------|----------|
| SIDE A | 0.313 | +/-0.010 | 315 | ✓ | vern | CNC-08 |
| | 2.360 | +0.005/-0.000 | 2.363 | ✓ | | |
| | 2.360 | +0.005/-0.000 | 2.363 | ✓ | | |
| | 2.366 | +0.005/-0.000 | 2.367 | ✓ | | |
| | 2.473 | +0.005/-0.000 | 2.477 | ✓ | | |
| | 2.573 | +0.005/-0.000 | 2.588 | ✓ | | |
| | 2.673 | +0.005/-0.000 | 2.677 | ✓ | | |
| | 2.750 | +0.005/-0.000 | 2.750 | ✓ | | |
| | 2.750 | +0.005/-0.000 | 2.750 | ✓ | | |
| | | | | | | |
| SIDE B | 0.313 | +/-0.010 | .315 | ✓ | vern | CNC-08 |
| | 2.360 | +0.005/-0.000 | 2.363 | ✓ | | |
| | 2.360 | +0.005/-0.000 | 2.363 | ✓ | | |
| | 2.366 | +0.005/-0.000 | 2.367 | ✓ | | |
| | 2.473 | +0.005/-0.000 | 2.477 | ✓ | | |
| | 2.573 | +0.005/-0.000 | 2.573 | ✓ | | |
| | 2.673 | +0.005/-0.000 | 2.676 | ✓ | | |
| | 2.750 | +0.005/-0.000 | 2.750 | ✓ | | |
| | 2.750 | +0.005/-0.000 | 2.750 | ✓ | | |
| | | | | | | |
| | 0.126.528 | +/-0.020 | 126.528 | ✓ | tape | ALG-25 |

| | | |
|---------------------------|--------------------------------|--------------------------------|
| Measured by: gmm.c | Audited by: [Signature] | Prototype Approval: N/A |
| Date: 12/06/21 | Date: 12-6-26 | Date: N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|------------------------------|------------|----------|
| A | 08.11.07 | New Issue (P/O D212-664-107) | KJ/EC | |
| B | 10.02.02 | Dimension 126.528 was 126.53 | KJ | |

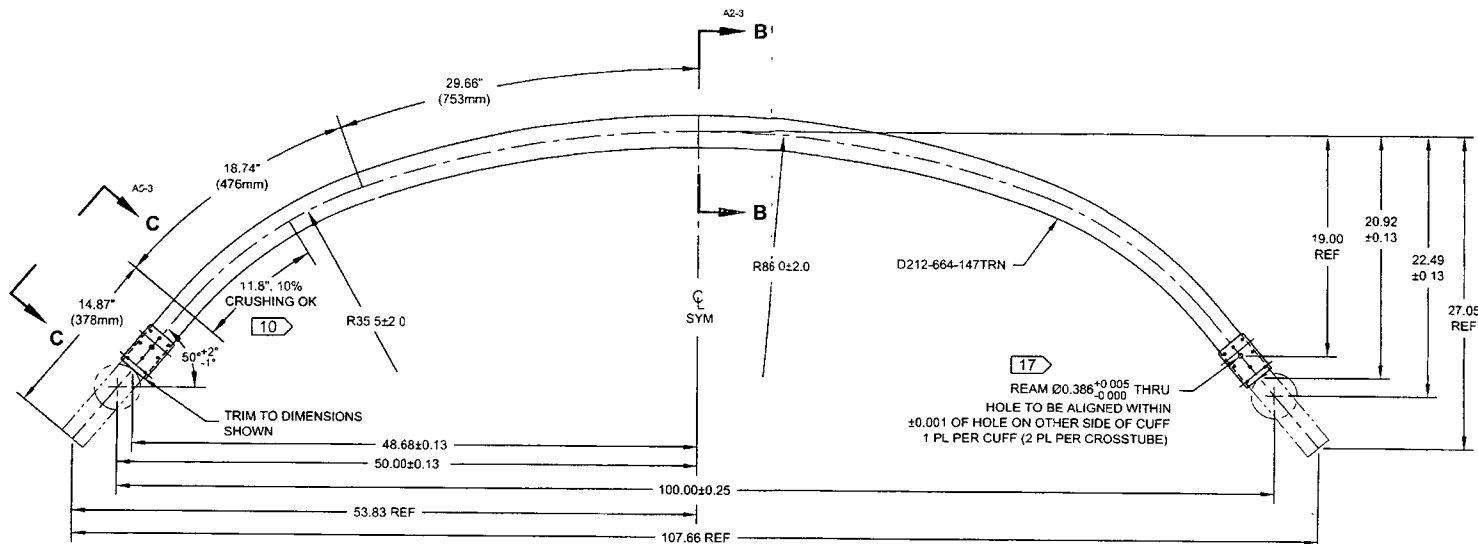
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

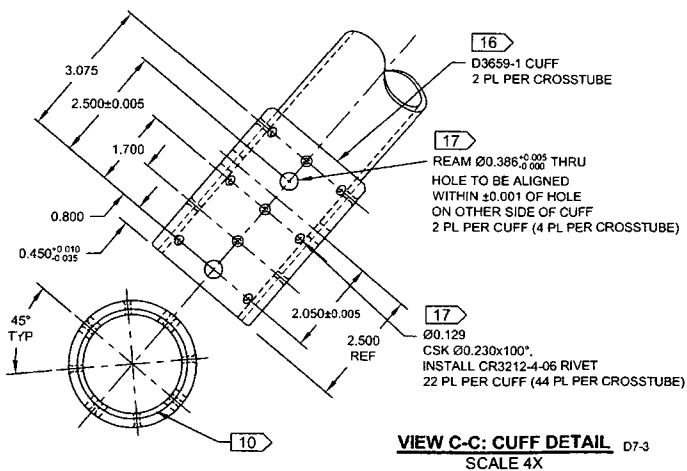
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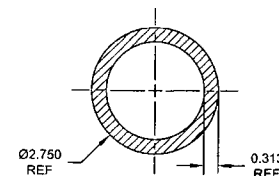


79679

D212-664-507
BENDING AND DRILLING DETAIL 10 B



VIEW C-C: CUFF DETAIL D7-3
 SCALE 4X



SECTION B-B D5-3
 SCALE 4X

LOW FWD
 09.07.20
 UNDER REVIEW
 09.10.13

RELEASED
 2009-10-29

| | | | |
|------------|----------|---|--------------|
| DESIGN | 90 | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | 98 | DRAWING NO. | REV. B |
| MFG. APPR. | 98 | D212-664-147 | SHEET 3 OF 4 |
| APPROVED | 99 | TITLE | SCALE |
| DE APPR. | 99 | CROSSTUBE (205/212/412 LOW FWD) | NTS |
| DATE | 09.09.30 | COPYRIGHT © 2007 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small> | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

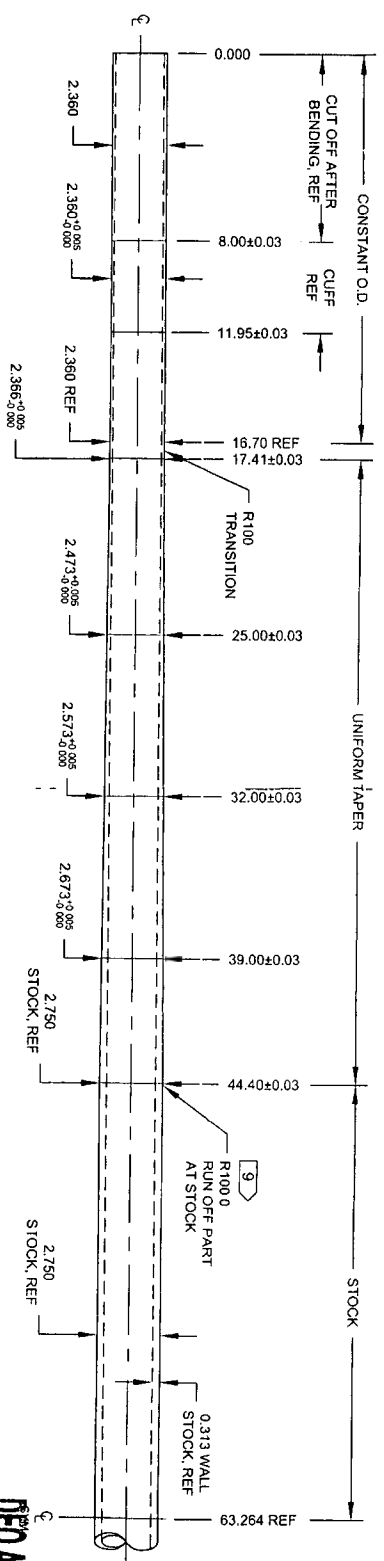
29679

DEO ATTACHED

CCO #1-614
11.07.26
UNDER REVIEW
04.06.13

RELEASED
2009-10-29

D212-664-147TRN
TURNING DETAIL



| | | |
|------------|----------|----------------------------------|
| DESIGN | 47 | DART AEROSPACE LTD |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | 47 | DRAWING NO. |
| MFG. APPR. | 47 | D212-664-147 |
| APPROVED | 47 | REV. B |
| DE APPR. | 47 | SHEET 4 OF 4 |
| DATE | 09.09.30 | TITLE |
| | | CROSS-TUBE (205/212/412 LOW FWD) |
| | | SCALE |
| | | NTS |

PROPERTY OF DART AEROSPACE LTD. ALL RIGHTS RESERVED. NO PART OF THIS DRAWING IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM.

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

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|-----------------------------|--|--------------------------|---|--|--------------------------------|---------------------------|--------------|
| DRAWING NO. D212-664-147 | TITLE CROSSTUBE ASS'Y (205 LOW FWD) | REV. B | DART AEROSPACE LTD ENGINEERING ORDER | | D.E.O. NO. D212-664-147-B-1 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN <i>92</i> | CHECKED <i>ASS</i> | MFG. APPR. <i>183</i> | APPROVED <i>MP</i> | | DE APPR. <i>MP</i> | | |
| DATE 11.07.15 | DATE <i>11.07.20</i> | DATE <i>11.07.21</i> | DATE <i>11/07/21</i> | | DATE <i>11.07.21</i> | | |

PURPOSE:

REPLACE MAGNOBOND WITH PROSEAL.

CHANGE:

IS:

| Item | Qty -147 | Qty -147B | Part Number | Description |
|------|-------------|--------------|-----------------|-------------------------------|
| 9 | A/R | A/R | PROSEAL 890 B-2 | SEALANT, AMS-S-8802 CLASS B-2 |

WAS:

| | | | | |
|---|-----|-----|----------------|---|
| 9 | A/R | A/R | MAGNOBOND 6398 | ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE) |
|---|-----|-----|----------------|---|

NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) TO INSTALL D2893-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**

WAS:

- 12) INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
2011-07-28
WV

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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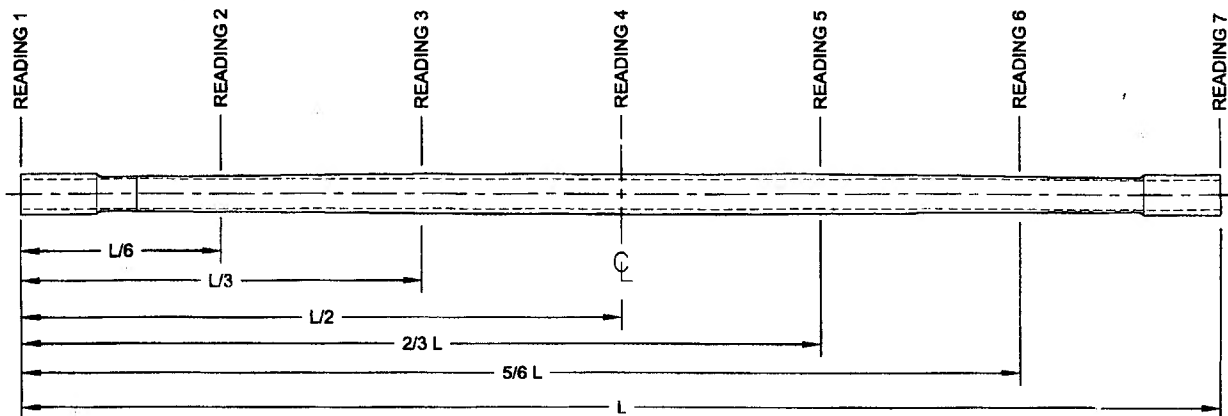
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NOTE: Date & initial all entries

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| DART AEROSPACE LTD | Work Order: 79679 |
| Description: Crosstube Assembly (205/212/412 Low Fwd) | Part Number: D212-664-147 |
| Inspection Dwg: D212-664-147 Rev: B | Page 2 of 2 |

WALL THICKNESS MEASUREMENT



| Location | WALL THICKNESS MEASUREMENT (IN) | | | | Deviation Δw (max-min) | TOLERANCE |
|--------------------------------|---------------------------------|------|------|------|--------------------------------------|-----------|
| | w1 | w2 | w3 | w4 | | |
| READING 1 L= 0" <i>cuft</i> | .119 | .112 | .119 | .129 | .017 | 0.048" |
| READING 2 L= 21" | .149 | .139 | .155 | .164 | .025 | |
| READING 3 L= 42" | .301 | .291 | .298 | .315 | .024 | |
| READING 4 L= 62.25" | .323 | .313 | .316 | .331 | .018 | |
| READING 5 L= 21" | .163 | .153 | .153 | .160 | .010 | |
| READING 6 L= 42" | .310 | .299 | .303 | .316 | .017 | |
| READING 7 L= <i>cuft</i> | .115 | .128 | .120 | .119 | .013 | |

Calibration Result

Actual Block Thickness: _____

Sitescan 250 Measured Thickness: _____

| |
|---------------------------------|
| Measured by: <i>mm.l</i> |
| Date: 12/06/26 |

| |
|------------------------------|
| Audited by: <i>DP</i> |
| Date: 12-6-26 |

| | |
|----------------------------|-----|
| Prototype Approval: | N/A |
| Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|------------------------------|------------|----------|
| A | 08.11.07 | New Issue (P/O D212-664-107) | KJ/EC | |
| B | 10.02.02 | Dimension 126.528 was 126.53 | KJ | |
| C | 12.06.04 | Wall thickness form added | KJ | |